

Work Order ID 114008-2 *split*

March-07-14 12:58:41 PM

114008

Page 1

Item ID: D4822-1

Revision ID:

Item Name: Upper Deflector, LH

Start Date: 2/28/14 Start Qty: 11.00

Required Date: 3/07/14 Req'd Qty: 11.00

Reference: REWORK -ECN14-516

Accept *split*
3X

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: *u*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4822

C

101

0.00

101

Outsource5

Memo

0.00

Outsource process - Machining

PULL FROM STK:

1 X D4822-1 b106972

9 X D4822-1 B109242

SEND TO WEJAY FOR REWORK PER REV. C

PO 23205

103

Receive & Inspect for Damage & Mat'l Certs

0.00

103

Packaging

Memo

0.00

Packaging

CZ 14/03/03 11

10x SP 15-06-15

Work Order ID 114008

March-07-14 12:58:41 PM

114008

Page 2

Item ID: D4822-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Upper Deflector, LH
 Start Date: 2/28/14 Start Qty: 11.00 *11* Cust Item ID:
 Required Date: 3/07/14 Req'd Qty: 11.00 *11* Customer:
 Reference: REWORK -ECN14-516

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

105

105

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⑤ 15-06-19 DAS
9
9-89

116

116

SprayPaint

Spray Painting

Issue P/O -

Memo

0.00

0.00

touch up holes with primer

B

CY JUN 22 2015 10

strip and prime sent to ATG

hand analyze
+ prime P/O: 28906

122

122

QC

Quality Control

QC14 Inspect Spray Paint

0.00

RCV -

Memo

0.00

2x SP15-07-16

QC6

→ ③

DAS
9
9-89

15-07-17

Work Order ID 114008

March-07-14 12:58:41 PM

114008

Page 3

Item ID: D4822-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Upper Deflector, LH
 Start Date: 2/28/14 Start Qty: 11.00 *11* Cust Item ID:
 Required Date: 3/07/14 Req'd Qty: 11.00 *11* Customer:
 Reference: REWORK -ECN14-516

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location <i>CCPS6</i>	0.00							
170									
Packaging	Memo	0.00							
Packaging	re-identify using new B/N								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

3 *DAS* 6 *9-89* JUL 19 2015

15/7/20 *15*

1.223/105 JUL 20 2015

Picklist Print

March-07-14 12:58:40 PM

Page 1

Work Order ID: 114008

114008

Parent Item: D4822-1

D4822-1

Parent Item Name: Upper Deflector, LH

Start Date: 2/28/14

Required Date: 3/07/14

Start Qty: 11.00

Required Qty: 11.00

Comments: IPP REV:A NEW ISSUE 13-04-19 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4822-1		Manufactured	No				Each	0.0000		11			

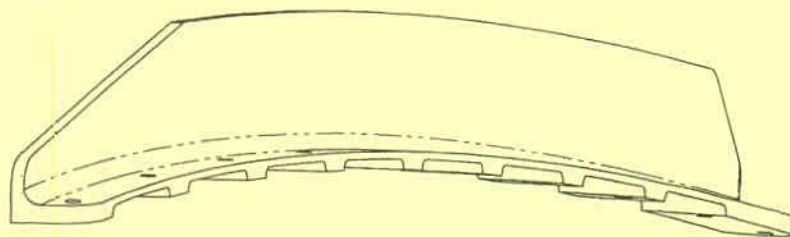
D4822-1

Upper Deflector, LH

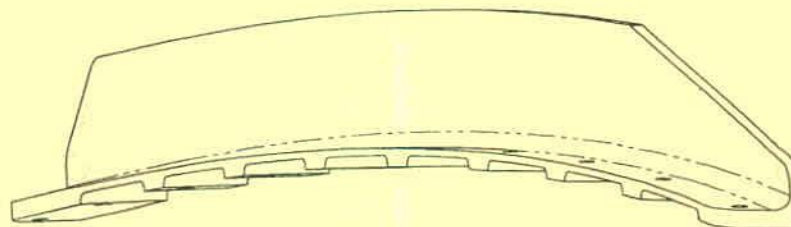
**

10x 8015-0615
1x D4822-1 B106472 L

10x 04822-1 B109242 14.02-28



D4822-1 UPPER DEFLECTOR LH



D4822-2 UPPER DEFLECTOR RH

Mo 11408

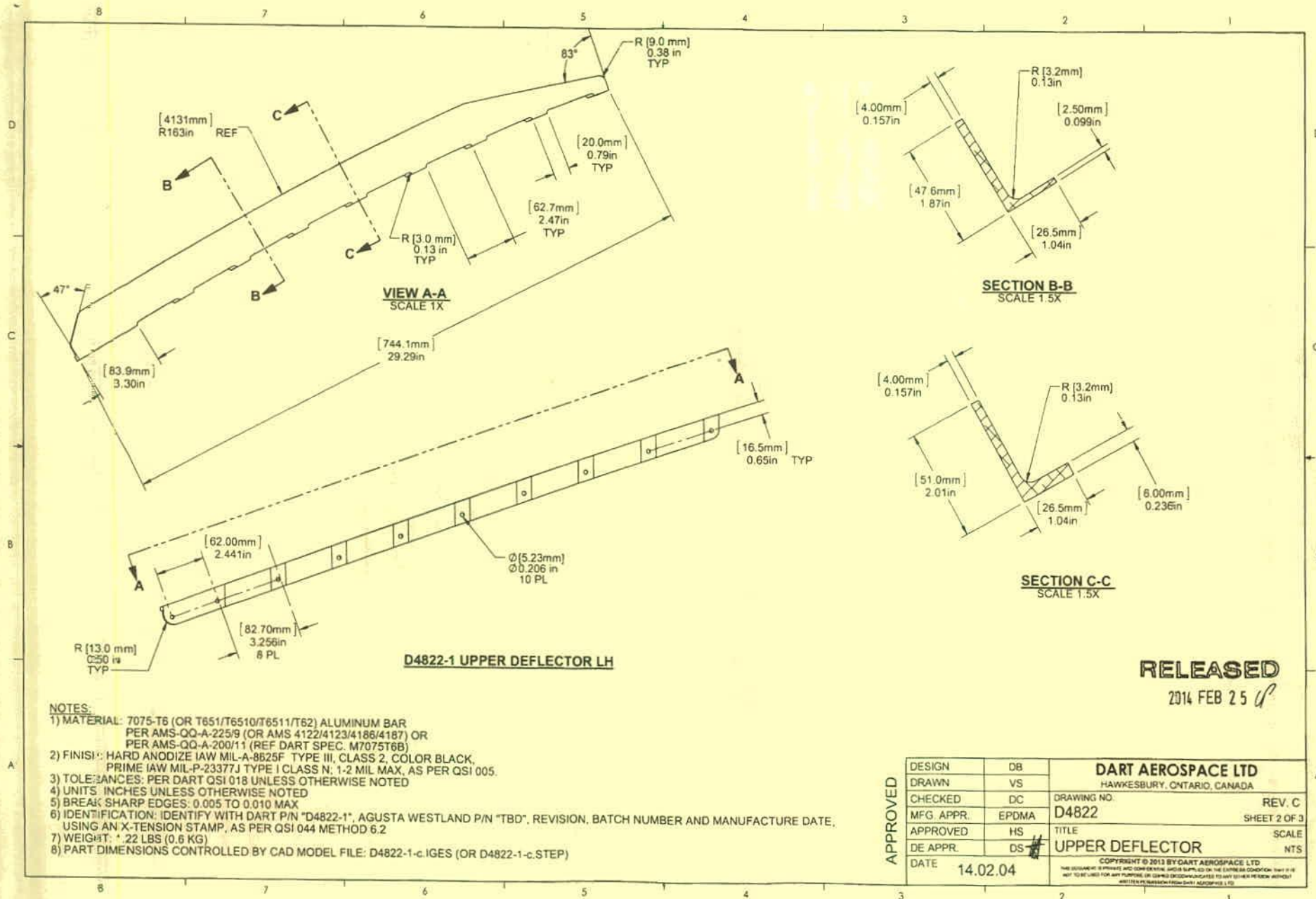
RELEASED

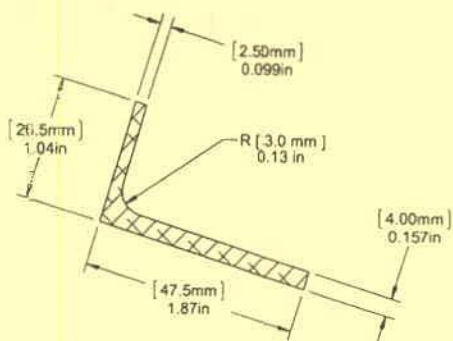
2014 FEB 25

ECU 14-514

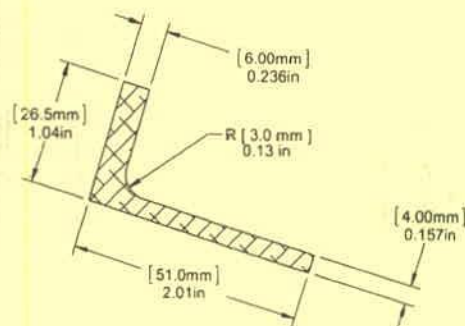
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	EPDMA	D4822	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	UPPER DEFLECTOR	NTS
DATE	14.02.04	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. IT IS TO BE SUPPLIED ON THE SUPPLIER'S CONFIDENCE THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

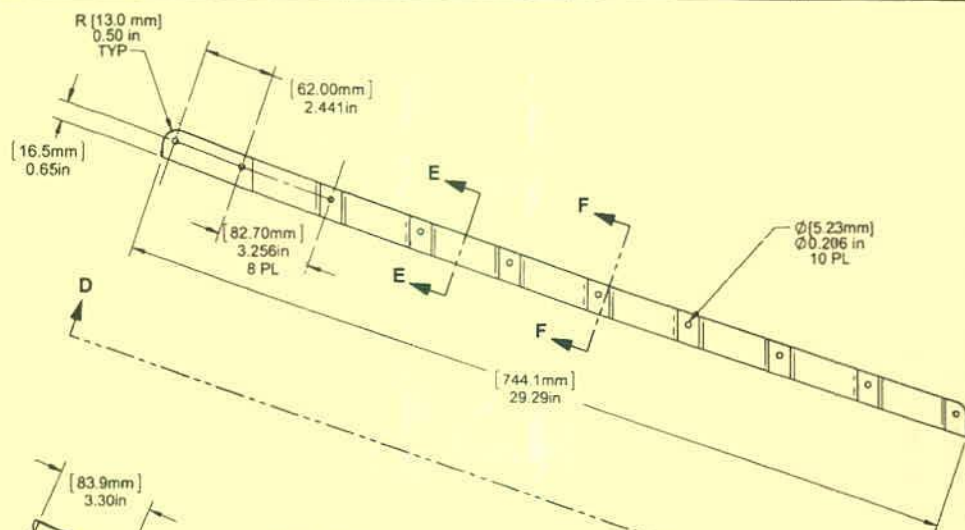




SECTION E-E
SCALE 2X



SECTION F-F
SCALE 2X



VIEW D-D
SCALE 1X

D4822-2 UPPER DEFLECTOR RH

RELEASED

2014 FEB 25 *dp*

NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC. M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625F TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-23377J TYPE I CLASS N: 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4822-2", AGUSTA WESTLAND P/N "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE,
USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 1.22 LBS (0.6 KG)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4822-2-c.IGES (D4822-2-c STEP)

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	EPDMA	D4822	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	UPPER DEFLECTOR	NTS
DATE	14.02.04	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE, AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Linda Lacelle

From: David Shepherd
Sent: March-07-14 10:28 AM
To: Pablo Bravo; Linda Lacelle
Cc: Mike Petsche; Bill Beckett
Subject: RE: 169 CCS Wiper Deflectors

Yes ... I'm good with that ... Didn't realize that the parts were already anodized and primed.

Regards,
David

From: Pablo Bravo
Sent: March-07-14 8:26 AM
To: Linda Lacelle
Cc: David Shepherd; Mike Petsche; Bill Beckett
Subject: Re: 169 CCS Wiper Deflectors

I would think that since it's a trial fit we would just need to apply touch up primer to the holes and maybe an Alodine solution before primer.

Shep, what say you?

On Mar 7, 2014, at 7:21 AM, "Linda Lacelle" <llacelle@dartaero.com> wrote:

Sorry, maybe I'm wasn't clear. They are already anodized and primed, but they have been drilled to the latest revision, so the holes are not anodized and primed, since this is just a trial fit, I was just wondering if they needed to be touched up anodize/prime..

Thx
L

From: David Shepherd
Sent: March-07-14 10:10 AM
To: Linda Lacelle; Mike Petsche
Cc: Pablo Bravo; Bill Beckett
Subject: RE: 169 CCS Wiper Deflectors

I would say "YES" ... let's anodize and paint them.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23205

Purchase Order Date 3/3/2014
PO Print Date 3/3/2014

Page Number 2 of 3

Order From : VC-WMP001
WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-384-1662

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms COD
Currency CAD
FOB Destination-Collect

114008

~~45222~~
D4822-1 MOD UPPER
DEFLECTOR

3/28/2014

10.00

\$96.00

\$960.00

Yes

3/28/2014

RE-WORK AS PER ECN14-516 TO REV. C
DELIVERY DATE TBA FOR ITEM D4822-1 X 10 PCS

Handwritten notes:
recu 1x
recu 9x
8p15-de-15
15-de-15

Line Total: \$1,380.00

4 114009

D4822-2 MOD UPPER
DEFLECTOR

3/14/2014

1.00

\$420.00

\$420.00

Yes

3/14/2014

RE-WORK AS PER ECN14-516 TO REV. C

114009

3/28/2014

10.00

\$96.00

\$960.00

3/28/2014

RE-WORK AS PER ECN14-516 TO REV. C
DELIVERY DATE TBA FOR ITEM D4822-2 X 10 PCS

Handwritten notes:
recu 1x
8p15-de-15
recu 9x
8p15-de-15

Line Total: \$1,380.00

Note:

3/3/2014

Package Inquiry Home

 Package Tracking Exception List and HALL

Package Inquiry

Lonnie S. Tuck (224672)

eOps Home | Package Inquiry Help | eOpsInfo | Logout

Quick Navigation

Package Inquiry

Report run on Wed Jun 10 15:57:03 CDT 2015

PACKAGE TRACKING NUMBER: 773800099220

CLEAR

REFRESH

Package

Form ID:	0451 - Dom. Canada Automation TRK#	Service Commit Date/Time	06/11/2015 17:00:00
Ship Date:	06/10/2015	CDO Commit Date/Time	
Service Commit Area	PM	Destination LOC ID:	YMXA
Origin LOC ID:	YGKA	Handling Codes:	02-DELIVER WEEKDAY
Service/Packaging Type:	PRIORITY OVERNIGHT	Declared/Carriage Value:	
Package Weight:	42.50 lb	Total Customs Value:	
Total Packages: 1	PIECE 1 OF 1	Payment Type:	RECIPIENT ACCOUNT 151793240
Shipper Account:	153111154	Commodity Description:	
Shipper Reference:		MBG Service Classification:	
eSOL Service Classification:		Recipient Company:	DART AEROSPACE
Shipper Company:	WEJAY MACHINE	Name:	SHIPPING
Name:	ANGELA JANSEN	Address:	1270 ABERDEEN ST
Address:	600 OCONNOR DRIVE	Additional Address:	
Additional Address:		City:	HAWKESBURY
City:	KINGSTON	State/Province:	ON
State/Province:	ON	Postal:	K6A1K7
Postal:	K7P1N3	Country:	CA - CANADA
Country:	CA - CANADA	Recipient Phone:	6136329577
Shipper Phone:	6132841662		

PACKAGE TRACKING NUMBER: 773800099220

Scans

Filters									
All									
ID	TRACK TYPE	A S T R A	C O N S	SCAN DATE TIME	LOC ID	FedEx ID	SOURCE / SYSTEM NAME	S V C	STATUS / COMMENTS
6	SOPS	Y	Y	06/10/2015 16:47	YGKA	771761	PSCAN		CITY: KINGSTON STATE: ON --- POST DATE/TIME 06/10/2015 16:53:00
5	CONS	Y		06/10/2015 16:47	YGKA	771761	PSCAN		CONSOLIDATED ID: 216666427447 ULD: AYY0170FX DEST: YYZR M/S: N SPLIT NBR: 99 COMMENTS: DOMESTIC BOXES ULD 2 --- POST DATE/TIME 06/10/2015 16:48:53
4	Commit	N		06/10/2015 15:55				PO	SERVICE: PRIORITY OVERNIGHT DELIVER WEEKDAY --- POST DATE/TIME 06/10/2015 19:55:27 GMT
3	PUP	Y		06/10/2015 15:51	YGKA	215974	POWERPAD Scanned	PO	DISP NBR 00027 RT/248 SVC CMT: PM URSA 08 YMXA DEST ZIP/RTG K6A1 CITY: KINGSTON STATE: ON STOP TYPE: Oncall Meter LABELLED SERVICE: PRIORITY OVERNIGHT DELIVER WEEKDAY --- POST DATE/TIME 06/10/2015 15:55:27
2	REV	N		06/10/2015 17:09			ITIH CHRONOS	PO	SHPR: ANGELA JANSEN ORIG: YGKA SHPR ZIP: K7P1N3 RCPT: SHIPPING DEST: YMXA RCPT ZIP: K6A1K7 PKG WGT: 42.50 lb TOTAL SHIPMENT PIECES: 1 SERVICE: PRIORITY OVERNIGHT DELIVER WEEKDAY --- POST DATE/TIME 06/10/2015 17:09:25 GMT
1	Contract	N		06/10/2015 12:09			/SDSM	PO	Total Package Count: 1 SERVICE: PRIORITY OVERNIGHT



Packing Slip 36728A

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
 TEL: 613-384-1662 FAX: 613-384-2997
 www.wejay.com

SOLD TO: Dart Aerospace
 1270 Aberdeen Street
 Hawkesbury ON K0A 1H7

SHIP TO: Dart Aerospace
 1270 Aberdeen Street
 Hawkesbury ON K0A 1H7

INVOICE DATE	YOUR ORDER NO. P023205	DATE ORDERED 03/03/14	SHIPPED VIA Best way
CUSTOMER CODE	PROV. LIC. NO.	Extra ☐ Exempt ☐	TERMS

QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION	UNIT PRICE	AMOUNT
0		4	Modify windshield deflector (add holes) as per drawing ECN14-516 to Rev. B D4821-1 Part number: 114007		
0		10	Modify upper windsheild deflector (add holes) as per drawing ECN14-516 to Rev.C D4822-1 (Left Hand) Part number: 114008		
0		9	Modify upper windsheild deflector (add holes) as per drawing ECN14-516 to Rev.C D4822-1 (Right Hand) Part number: 114009		

SP15-06-15

RELEASE NOTE

I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order.

Inspection Supervisor

[Signature]
 WMP 03
 JUNE 10/15

G.S.T.

P.S.T.

ORDER: COMPLETE ☐
 PARTIAL ☐

TOTAL

RECEIVED BY _____

1.5% PER MONTH (18% PER ANNUM)
 CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
 PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: DART Aerospace	DATE: June 10, 2015		
	P.O.# PO23205		
	WEJAY JOB# 36728A		
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4821-1 'Windshield Deflector' Item# 114007	4	Added holes per ECN14-516 to rev. B D4821-1	D4821 /rev. B
D4822-1 'Upper Left Hand Windshield Deflector' Item# 114008	10	Added holes per ECN14-516 to rev. C D4822-1 (Left Hand)	D4822 /rev. C
D4822-2 'Upper Right Hand Windshield Deflector' Item# 114009	9	Added holes per ECN14-516 to rev. C D4822-2 (Right Hand)	D4822 /rev. C

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

Clifford Smith
Authorized Q.A. Signatory



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 36728A

PAGE: 1 of 1

CUSTOMER: Dart Aerospace

CUST. P.O.# PO23205

PART No. D4822-1

DESCRIPTION: Deflector Left Hand

DWG No. D4822

REV. C

E.C.O. --

MATERIAL: Existing Deflector D4822-1 rev. B

INSPECTOR: Cliff Smith

QUANTITY

ACCEPT:

REJECT:

N.C.R.#

DATE: June 10, 2015

REC'D: 1

1

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-

INSTRUCTIONS, COMMENTS: Standard Tolerances per DART QSI 018 unless otherwise noted
-First Article Inspection- new (rev. C) features only

ITEM REF. No.	CHARACTERISTIC (DIMS IN mm)	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	29.29"	View A-A	±.03	2/C6			
2	R163" ref		±.10	2/D7			
3	47°		±.5°	2/C8			
4	83°		±.5°	2/D5			
4A	R 0.38" typ.		±.03	2/D4			
5	3.30"		±.03	2/C8			
6	0.79" typ.		±.03	2/D5			
7	2.47		±.03	2/D5			
8	R 0.13 typ.		±.03	2/C6			
9	R0.50" typ		±.03	2/B8			
10	Ø0.206 hole thru	10 pl.	+0.005/ -.001	2/B5	.206/ .207	1	Accepted
11	2.441"		±.010	2/B7	2.443	1	Accepted
12	3.256" typ.	8 pl.	±.010	2/B7	3.255/ 3.257	1	Accepted
13	0.65" typ.	10 pl.	±.03	2/B4	.652/ .657	1	Accepted
14	0.157"	Section B-B	±.01	2/D3			
15	R0.13" typ.		±.03	2/D2			
16	.099"		±.01	2/D2			
17	1.04"		±.03	2/D3			
18	1.87"	Section C-C	±.03	2/D3			
19	0.236"		±.01	2/B1			
20	0.157"		±.01	2/C3			
21	2.01"		±.03	2/B3			
22	1.04"		±.03	2/B2			
23	R0.13"		±.10	2/C2			
24	Deburring	Per note 5	.005-.010	2/A8	passed	1	Accepted
25	Identification	Per note 6		2/A8			

EXERCITIO ARITHMETICAE

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28906**

Purchase Order Date 6/22/2015

PO Print Date 6/22/2015

Page Number 1 of 4

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

M132767

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments			Promise Date				
Delivery Comments							

1	114007	D4821-1 WINDSHIELD DEFLECTOR REV.B	7/10/2015		4.00	\$0.00	\$0.00
			Yes				
			7/10/2015				

RE-WORK STRIP PRIMER AND ANODIZE

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2
PRIME: AS PER IAW MIL-P-23377J TYPE I, CLASS N

Line Total:

\$0.00

2	114008	D4822-1 UPPER DEFLECTOR REV. C	7/10/2015		10.00	\$0.00	\$0.00
			Yes				
			7/10/2015				

RE-WORK STRIP PRIMER AND ANODIZE

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2
PRIME: AS PER IAW MIL-P-23377J TYPE I, CLASS N

Rec'd 3x.
SP-07-16

Note:

6/22/2015



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63820

Date: 16-Jul-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
10 ea	Part: ASST D4821-1 4x D4822-1 3x D4822-2 3x Srtip primer & re hard anodize as per mil-a-8625 ty III cl 2 primer as per mil-p-23377 ty I cl n Job: 20150544	Rev: <i>SP15-07-16</i> PO: PO28906 Line:	
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE: <i>16/7/15</i> CERTIFIED SIGNATURE: <i>[Signature]</i> RECEIVER SIGNATURE: _____			